

Work Order ID 108952

October-30-13 10:02:01 AM

108952

PRELIMINARY ISSUE

Page 1

Item ID: D4950-3

Accept

N900040100

Setup Start *NS1*

Revision ID: PRELIM

Item Name: Plate

Stop *NS2*

Start Date: 10/30/13 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 11/04/13 Req'd Qty: 8.00 *8*

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4950	PA1 A

100	FLOW WATER JET	0.00				8	0		A
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4950 Dwg Rev: PA1 Prog Rev: PA1 2-Deburr if necessary								13.10.30

110	QC2- Inspect parts off machine FAI/FAIB	0.00				8	0		A
110									
QC	Memo	0.00							
Quality Control									13.10.30

120	QC8- Inspect parts - second check	0.00				8			
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

B1030

Inspected as per
Dwg PA1

Work Order ID 108952

108952

Page 2

October-30-13 10:02:01 AM

Item ID: D4950-3

Accept

N900040100

Setup Start ***NS1***

Revision ID: PRELIM

Stop ***NS2***

Item Name: Plate

Start Date: 10/30/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/04/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

Small Fab

Small Fab

Small Fab

Memo

1- deburr

2- form as per dwg D4950

0.00

0.00

8

8/31/10/30

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS
27
9-88

131031

8

Inspect as per
dwg PA1

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

8

13-10-31

Work Order ID 108952

108952

Page 3

October-30-13 10:02:01 AM

Item ID: D4950-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Plate
 Start Date: 10/30/13 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 11/04/13 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 DAS 27 9-89 0.00 13.10.31				8			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>QA</u> Memo <u>Sylue > -013</u>	0.00 0.00			DAS 30 9-89	8			13/10/31
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							13/11/19

POSITIVE RECALL
 EFFECTIVE 13-10-30 AUTH MF
 RELEASED S DATE 13/11/14
 Part inputs to
 204

Picklist Print

October-30-13 10:02:01 AM

Page 1

Work Order ID: 108952

Parent Item: D4950-3

Parent Item Name: Plate

Start Date: 10/30/13

Required Date: 11/04/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.09.24 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125

Purchased

No

sf

146.1400

2

A

13.12-30

6061-T6 .125 Sheet

Location

Loc Qty

Loc Code

MAT021

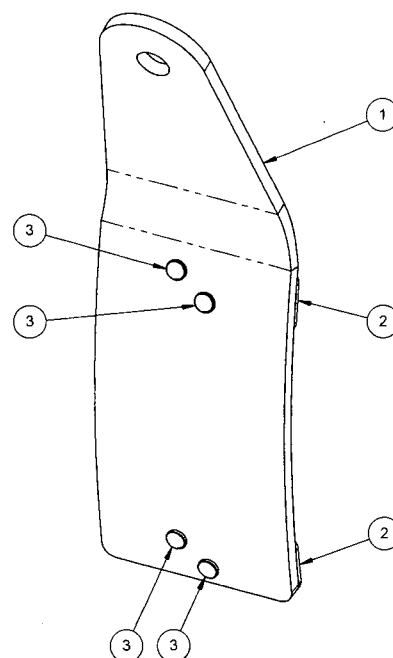
146.14

m127272

146.14

127272 → 2

ITEM NO.	QTY -041	PART NUMBER	DESCRIPTION
	X	D4950-041	TAILBOOM MOUNT
1	1	D4950-1	MOUNT
2	2	D3868-1	SPACER
3	4	MS20426AD3-6	RIVET



D4950-041 TAILBOOM MOUNT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4950-041" AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.12 lbs

PRELIMINARY ISSUE

13.09.23

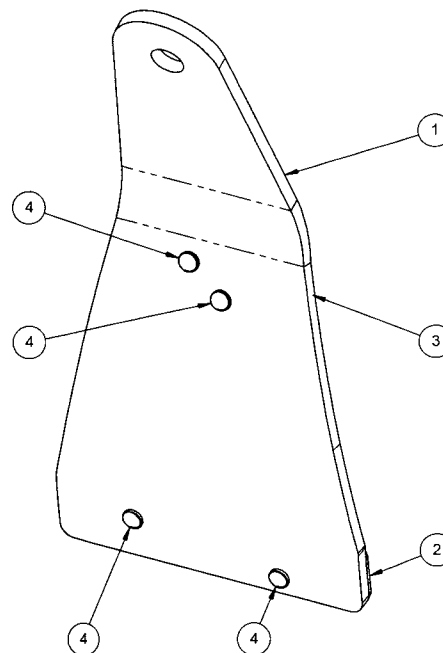
PA1	NEW ISSUE	MB	13.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	13.09.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4950
REV. PA1
SHEET 1 OF 6
TITLE MOUNT
SCALE NTS

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ITEM NO.	QTY -043	PART NUMBER	DESCRIPTION
	X	D4950-043	TAILBOOM MOUNT
1	1	D3866-3	MOUNT
2	1	D3868-3	SPACER
3	1	D3868-5	SPACER
4	4	MS20426AD3-6	RIVET



D4950-043 TAILBOOM MOUNT

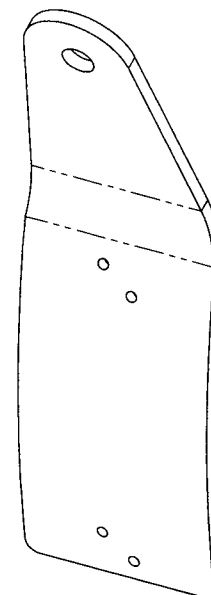
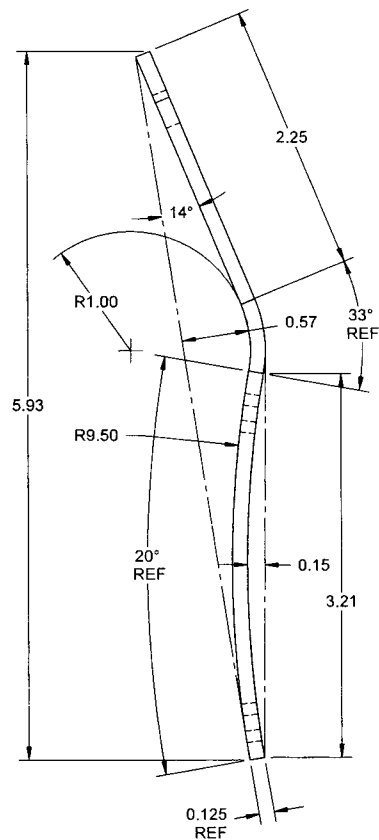
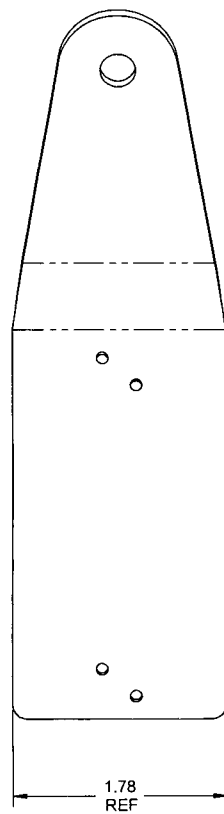
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4950-043" AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.15 lbs

PRELIMINARY ISSUE

13.09.23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4950	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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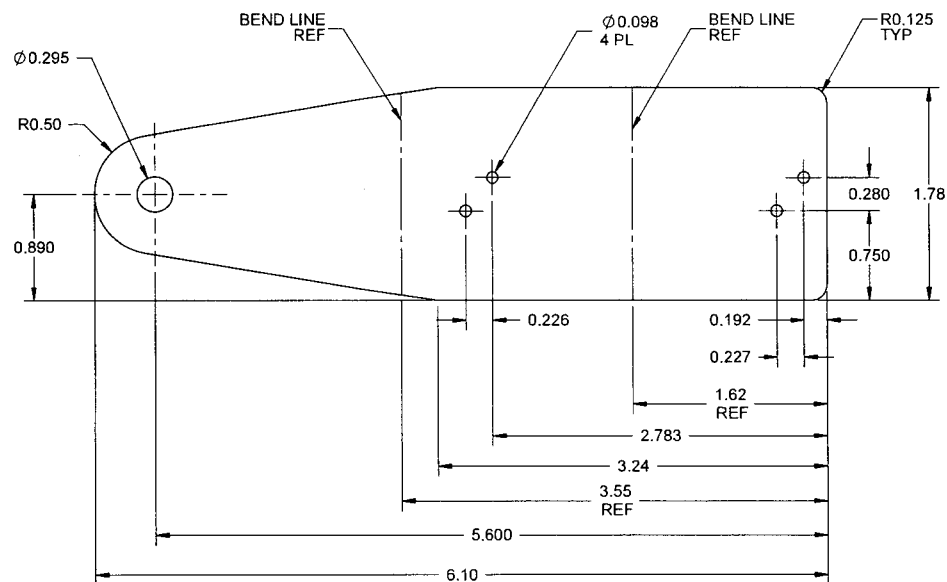
D4950-1 PLATE

- NOTES:**
- 1) MATERIAL: MAKE FROM D4950-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.11 lbs

PRELIMINARY ISSUE

13.09.23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4950	SHEET 3 OF 6
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D4950-1F FLAT PATTERN

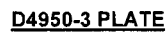
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

PRELIMINARY ISSUE

13.09.23

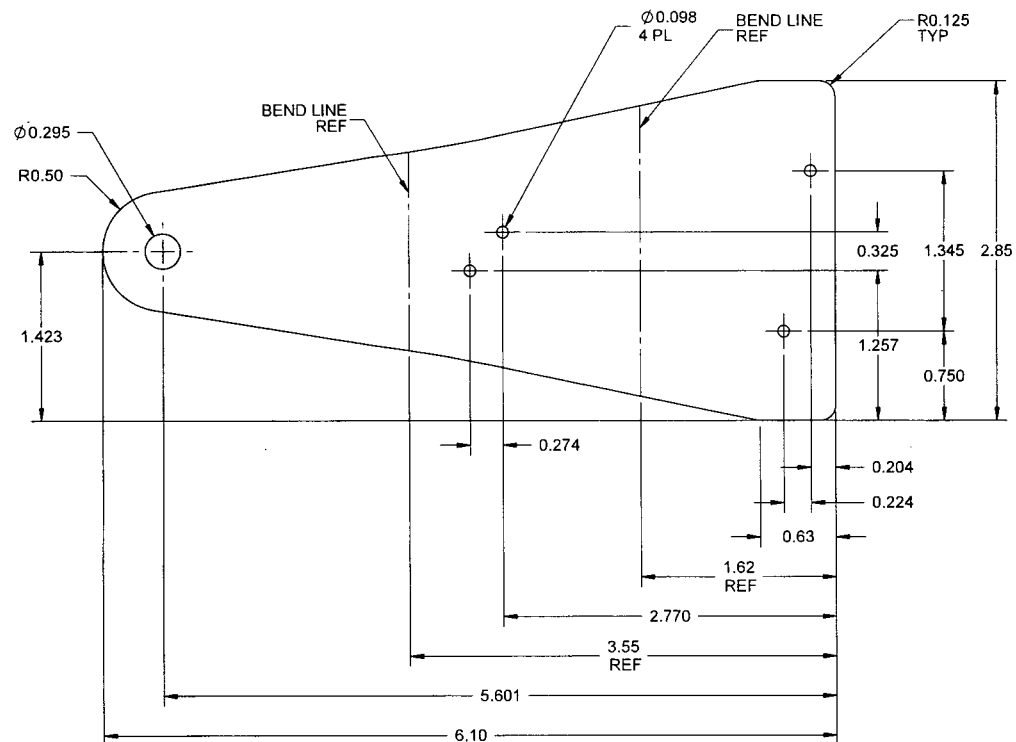
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA
MFG. APPR.		D4950	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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D4950-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

PRELIMINARY ISSUE

13.09.23

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PA1
MFG. APPR.		D4950 SHEET 6 OF 6
APPROVED		TITLE SCALE
DE APPR.		MOUNT NTS
DATE	13.09.23	

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DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.257	+/- .010	1.257	-		V	OKm - 01
.325	+/- .010	.325	-		V	
.750	+/- .010	.750	-		V	
1.345	+/- .010	1.345	-		V	
2.85	+/- .030	2.84	-		V	
.204	+/- .010	.204	-		V	
.224	+/- .010	.224	-		V	
.63	+/- .030	.63	-		V	
1.62	+/- .030	1.62	-		V	
2.770	+/- .010	2.770	-		V	
3.55	+/- .030	3.55	-		V	
5.601	+/- .010	5.601	-		V	
6.10	+/- .030	6.10	-		V	
.274	+/- .010	.274	-		V	
1.423	+/- .010	1.423	-		V	
Ø .295	+ .006 / - .001	Ø .295	-		V	
Ø .098	+ .004 / - .001	Ø .098	-		V	
.125	+/- .010	.121	-		V	

DAS

Measured by: <i>Ac</i>	Audited by: <i>27</i>	Preliminary Approval:
Date: 13.10.30	Date: 13-10-30	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

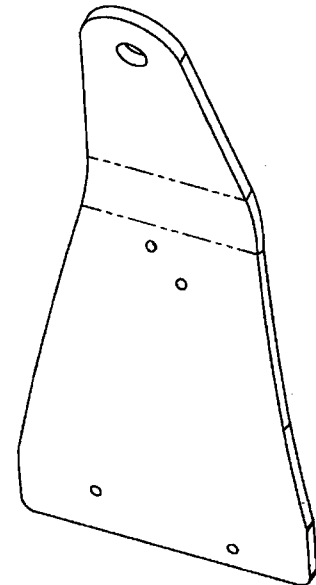
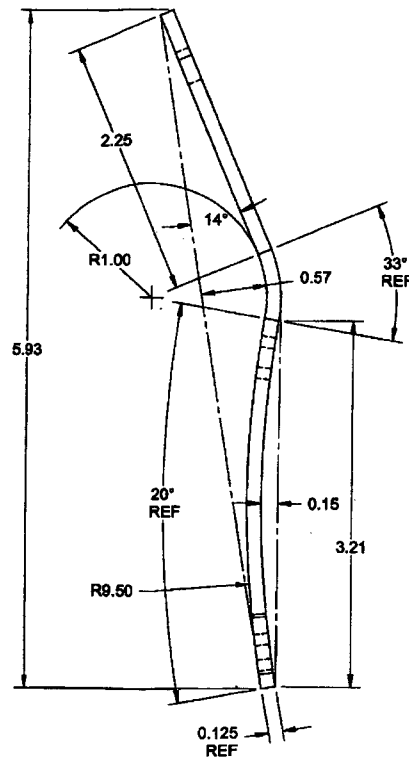
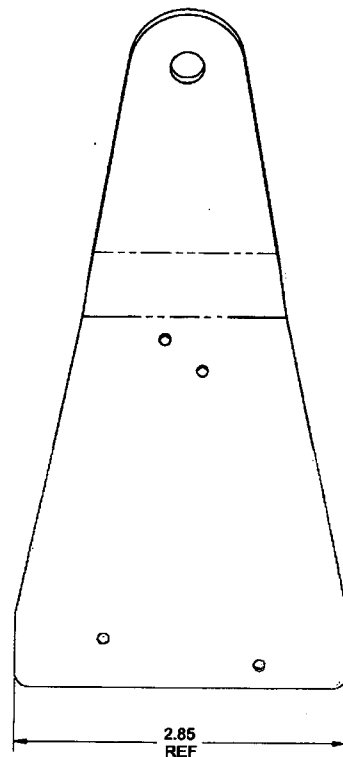
Description: Plate		Work Order: 108 952	
Inspection Drawing: D4950		Rev: PA1	Part Number: D4950 - 3

INSPECTION SHEET

[illegible]

Measured by: DAS 30 9-89	Checked By: DAS 36 9-89	QC inspector:	Engineering Approval (if necessary):
Date 13/10/30	Date 13/10/30	Date DAS 27	Date

13-10-31



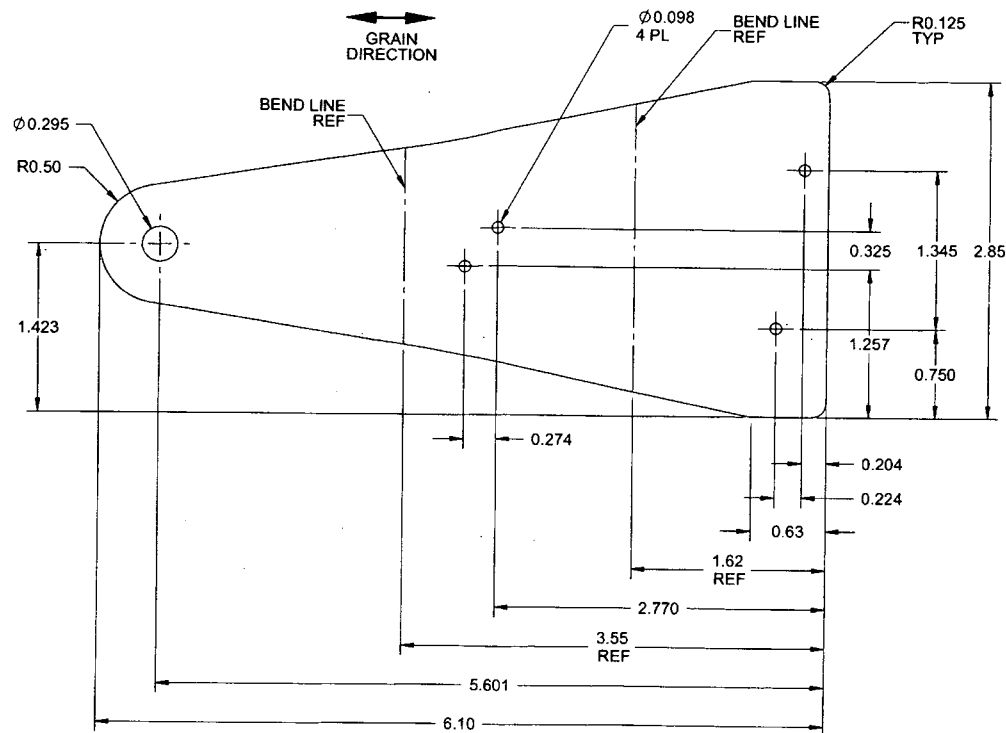
D4950-3 PLATE

RELEASED
R 2013 -10- 30 D

NOTES:

- 1) MATERIAL: MAKE FROM D4950-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4950	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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







D4950-3F FLAT PATTERN

RELEASED
2013-10-30

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.120.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4950	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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Receiving Report

Date:

13/10/24

Batch No:

M127272

Supplier:

Camp1

Dart P/O:

21654

Packing Slip:

Yes ☒

No ☐

Invoice:

Yes ☐

No ☒

Receipt:

Cash ☐

Cr ☒

Release Note Attached:

Yes ☒

No ☐

N/A ☐

Waybill Attached:

Yes ☐

No ☒

N/A ☐

Shipment Complete:

Yes ☒

No ☐

N/A ☐

QC6 Inspection

DAS ☒

N/A ☐

Work Order

16 ☐

N/A ☐

9-89 13/10/23

N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK)

Level 12

Production/Admin:

Date

Received/Costing

Initial

13/10/25
[Signature]

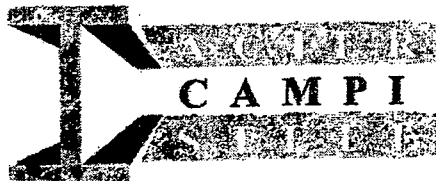
Location

Page 1 of 1

All amounts are calculated in domestic currency.

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-CAM002	Campi Steel								
PO21654	1		M6061T6S.125	sf	10/24/2013	10/25/2013	160.0000	\$5.83	0.0000	0	\$932.08
CAD	No		6061-T6 .125 Sheet m127272	sf	160.0000	DESJ02		\$932.08	0.0000	0	
	2		M6061T6S.032	sf	10/24/2013	10/25/2013	336.0000	\$1.72	0.0000	0	\$577.50
	No		6061-T6 Sheet 0.032" m127272	sf	336.0000	DESJ02		\$577.50	0.0000	0	
Total Received Quantity:											496.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$1,509.56
Total Balance Due Quantity:											0.0000



935, boul. du Havre
Valleyfield, Québec
J6S 5L1

Valleyfield
Tél.: 450 377-4248
Fax : 450 377-5696

Montréal
Tél.: 514 336-4248
Fax : 514 336-4246

Ontario
Tél.: 1 800 667-4248
Fax : 1 866 456-4242



VENDU À / SOLD TO :

613-632-5200 613-632-1053

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

EQUIP: LIFT

EXPÉDIER À / SHIP TO :

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

COMMANDE
ORDER N° 222852

DATE 21/10/13

BON DE LIVRAISON
PACKING SLIP N°

DATE DE LIVRAISON
DELIVERY DATE 24/10/13

VOTRE N° DE COMMANDE / YOUR P.O. N°	VEND./SALES M.	CODE CLIENT / CUST. CODE	EXPÉDIER PAR / SHIP VIA	TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
P021654	V	DAER	12345	NET 30 JOURS	2R		001

CODE DE PRODUIT PRODUCT CODE	COMMANDE ORDERED	EXPÉDIE SHIPPED	DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
			MILL TEST REQUIS***				
PAL48186061	5		AL.6061T6 SHEET.125 48 X 96 5 X 4' X 4' HEAT: 67075 ON SKID	205.00			
	7		AL.6061T6 FLLE .032" (20G) 7 X 4' X 12' HEAT: 643017 ON SKID	7.00			

* Unités de mesure / Units of measure: CLB Cost (100) livres / Hundred pounds CPI Cost (100) piéds / Hundred feet UN Unit / Unit PI Pieds / Feet PC Pied carré / Square foot

POIDS TOTAL
TOTAL WEIGHT 292

CONDITIONS :
LES MATÉRIAUX LIVRÉS ET FACTURÉS TELS QUE DÉCRITS DEMEURENT LA PROPRIÉTÉ DE "ACIER CAMPB INC." JUSQU'À PAYEMENT COMPLET ENCAISSÉ. LES RISQUES DE Perte DU BIEN SONT À LA CHARGE DE L'ACHETEUR. LA GARANTIE DE QUALITÉ DU MATÉRIEL EST LA MÊME QUE CELLE DU FABRICANT. L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES : NET 30 JOURS DE LA DATE DE FACTURATION, ET TOUT COMPTÉ IMPAYÉ DANS LES 30 JOURS ENTRAÎNE DES FRAIS DE 2% PAR MOIS (2% PAR ANNEE) QU'IL ACCEPTÉ DE PAYER. TOUT DÉFAUT D'ÉCHÉANCE LÈVE OU L'AUTRE DES OBLIGATIONS EN VERTU DU PRÉSENT CONTRAT ENTRAÎNE LA DÉCHÉANCE DU TERME ET PERMET AU VENDEUR, À SON CHOIX, DE RÉCLAMER TOUT SOLDE DU PRIX DE VENTE OU REPRISE DU BIEN VENDU. TOUTE RÉCLAMATION DOIT ÊTRE FAITE DANS LES CINQ JOURS, SUR PRÉSENTATION DE CE DOCUMENT. TOUTE MARCHANDISE ENDOMMAGÉE, ALTÉRÉE OU COUPÉE NE PEUT ÊTRE REPRISE. AUCUN RETOUR DE MARCHANDISE NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. TOUTE MARCHANDISE RETOURNÉE EST SOUJETTE À DES FRAIS DE MANUTENTION DE 25%.

CONDITIONS :
ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "ACIER CAMPB INC." UNTIL PAYMENT IS MADE FULL, COMPLETE AND CASHED. ALL LOST MATERIALS ARE AT THE BUYER'S EXPENSE. ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. THE BUYER HEREBY ACCEPTS TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY ADMINISTRATION CHARGES OF 2% PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. ANY DEFAULT IN RESPECT WITH THIS CONTRACT WILL LEAD TO PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE, TO CLAIM FOR THE BALANCE DUE OR THE REPOSSESSION OF THE GOODS SOLD. ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. ANY MERCHANDISE THAT HAS BEEN DAMAGED, CUT OR MODIFIED CANNOT BE RETURNED. ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE SUBJECT TO A 25% RESTOCKING CHARGE.

SOUS-TOTAL
SUB TOTAL

T.P.S.
G.S.T.

T.V.Q. / T.V.H.
G.S.T. / H.S.T.

TOTAL

PRÉPARÉ PAR / PREPARED BY VÉRIFIÉ PAR / VERIFIED BY

LIVRÉ PAR / DELIVERED BY HEURE / TIME

MARCHANDISE REÇUE EN BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION



A/Y M/M J/D

SIGNATURE DU CLIENT / CUSTOMER'S SIGNATURE

DATE

N° FNR TPS / GST RFR N° R 135 534 717

N° ENR. TVQ / GST REG. N° 1 015 668 543

SCRIPTO-1971

IFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per:

Rob Woodall

Rob Woodall
Director of Manufacturing Davenport Works

Terrance Thom

Terrance Thom
Quality Assurance Manager

1609532

Ship Date

0

B.L. No.

Invoice No.

Alcoa No. Item

2013-09-05

8692493

00000

1000504689-2

DPE-04689-2

P.O. No./Sovl Contract No.

Customer

Alcoa Item

67075 Ln#: 1

LT G041094176R16

Page 1 of 2

Item Description

0.125 IN TK (+0.0000 -0.0060) X 48.0 IN W (+.125 -
.125) X 96.0 IN LN (+.125 -.125) (N) A/T 6061-
T6 FLAT SHEET FOR DISTRIBUTORS
TOLERANCE GUARANTEED. AMS4027 REV N
EXC MRK ASTM B209 REV 10 CMM P025 REV U
((MARKED)) KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-
40 % CQR 0209971 REV 15 CUST REQ 13-07-
27 *** W/E 13-08-31 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	554300	521111	2596	48	PC	47397 27887 0000827
2	554309	521111	4174	77	PC	47397 27887 0000828
			6770	125		

Notes for CQR: 0209971.15

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISION DATED 1997-08-01.

CQR: 0209971.15 -Specification Limits

Temp	Dir	UTS	TYS	SL4D
T6	Long Transv.	KSI	KSI	PCT
Max				
Min		42.0	35.0	10

Chemical Composition

	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05
	Min	0.40		0.15		0.8	0.04			

REMAIN

13/10/25

IFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

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For:

Rob Woodall

Rob Woodall
Director of Manufacturing Davenport Works

Terrence Thom

Terrence Thom
Quality Assurance Manager

1609532

0

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

2013-09-05

8692493

00000

1000504689-2

DPE-04689-2

P.O. No./Govt Contract No.

Customer

Alcoa Item

C 67075 Ln#: 1

LT G041094176R16

Page 2 of 2

CQR: 0209971.15 -Specification Limits (cont.)

Lot: 521111 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No-> Test	UTS			TYS			EL4D		
			KSI	KSI	PCT	KSI	KSI	PCT	KSI	KSI	PCT
T6	Long Transv.	6	50	43.9	13.2	50	43.9	13.2	50	43.9	13.2
			49.9	43.8	13.2	49.9	43.8	13.2	49.9	43.8	13.2
			50.3	44.3	13.5	50.3	44.3	13.5	50.3	44.3	13.5
			50.1	43.9	13.1	50.1	43.9	13.1	50.1	43.9	13.1
			49.7	43.6	13.3	49.7	43.6	13.3	49.7	43.6	13.3
			49.7	43.5	13.7	49.7	43.5	13.7	49.7	43.5	13.7

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H3926015	Actuals	0.65	0.4	0.21	0.06	1.0	0.16	0.04	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO21654**

Purchase Order Date 10/9/2013

PO Print Date 10/22/2013

Page Number 1 of 1

Order From :

VC-CAM002

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 800 667 4248

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

REVISED
QTS. 032"

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	M6061T6S.125	6061-T6 .125 Sheet	10/16/2013 Yes 10/16/2013		160.00 sf	\$6.00	\$960.31
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MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209

Line Total: \$960.31

2	M6061T6S.032	6061-T6 Sheet 0.032"	10/16/2013 Yes 10/16/2013		336.00 sf	\$1.77	\$594.99
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AS ABOVE

Line Total: \$594.99

PO Total: \$1,555.30

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.
No substitution or deviation without consent.
Certificate of Conformity or Material Certification required **YES** NO
PST# 6122-5207

Change Nbr: 3

Change Date: 10/22/2013